Work Order ID 9 December-19-12 2:37:57 F	M	9317	*940	680 *	· · · · · · · · · · · · · · · · · · ·	·		Page 1
Item ID: 647.9317 Revision ID: Item Name: RH Bracket	\	6 A 7 . 680	Accept	*N900	N40100)* Se	tup Start Stop	*NS1* *NS2*
Start Date: 1/17/13 Required Date: 1/17/13	Start Qty: Req'd Qty:	-	• •	Cust Item I	ID:			
Reference:		·				Rı	ın Start	de North Andre
Approvals: Process P	lan:	Date://	Tooling:	D	ate:	K		*NR1*
QC:	· · · · · · · · · · · · · · · · · · ·	Date:	SPC (Y/N):	D	ate:		Stop	*NR2*
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool # Plan Code	Accept Qty	Qty N	Reject Insp. Number Stamp
Draw Nbr R	evision Nbr		`				10.	
647.9300			·	·				
100			0.00	40				
100 Bandsaw		emo	0.00	SI 13-02-24		20		<u> </u>
Jeaspa Bandsaw	CU	JT AT 12.0" LONG			;			
110			0.00		,			1 1
110 Outsource5		emo * i (2.2.1.1	0.00				Pl	13-03-1
Outsource process - Machining	PO	SUE P/0: // / / / / / / / SSIBLE SUPPLIER: ARCHE rtificate of conformaty require	*					,
	Ce	numeate of comorniary require	λι ,					
115	Receive & Insp	ect for Damage & Mat'l Certs	0.00		-			
115 Packaging	Me	emo	0.00			· .	[-13]	14/30 (17)
Packaging		•	à.		•			

											DQA	: Date	2: ,
NCR:	Yes /	No				WORK ORDER NON-O		NFORM	MANCE / UPD	ATE			ζ,
	·								•		QA Closed	: Date	2:
144 - 114 O 11 d						DISPOSITION				AGAINST D	EPARTMEN	T/PROCESS	
Work Orde	er:			<u>.</u>		Downst	ı l		المطيية لمناد	Crosstube	٦	Water Jet	Engineering
Dort N	u a					Rework	1		Skid-tube Machining	Small Fab		od. Eng. Coor.	Quality
Part N	···.					Scrap Use-as-is	1		noforming	Finishing		ore/Packaging	Other
NCR I	No					Work Order Update	1		Large Fab	Composite	1 1160/31	Supplier	
Neitt	•0					Work Order Opdate	J		carge rab	composite	_	3upplier [
Root					Descri	ption of work order update	T	nitial	Acti	on	Sign &		
Cause	D	ate	Step	Qty	(or Non-conformance	Ch	ief Eng	Descri	ption	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling											1		
Operator													
Material													
Setup													
Other												1	
Process													
Supplier											1		
Training		1					1						
Unapproved													
						F	AUL	T CATE	GORY				
Landi	ng Gear				_	General				<u></u> -	_	r	
	Ben	ding				Bend		Grain		L	Ovalized		Pressure/Forced
	Cen	tre No	t Concer	ntric to	o/s	BOM/Route		Hardwa	re		Over/Unde	er tolerance	Temperature/Cure
	Cra	cks			L	Broken/Damaged	L	Inspecti	on Incomplete	L	Part Incor	ect	Weld
	Cru	shed/C	rimped,			Burrs		Instruct	ions Incomplete/U	Inclear	Part Lost/I	Missing	Wrong Stock Pulled
	Cuf	fs				Contamination	1	Mainte	nance		Part Move	d	

Mislabeled

Out of Calibration

Out of Sequence

Outside Dimensions

Misread

Offset

Positioned Wrong

Power Loss/Surge

Other

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

Countersink

Cut Too Short Drill Holes

Drawing

Finish

Folio

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Work Orde December-19-12				*946	380*							Page
Item ID: Revision ID: Item Name:	647.9317 RH Bracket			Accept	*N900)040	100)* s	Setup	Start Stop	ı VI -	S1* S2*
Start Date: Required Date: Reference:	1/17/13 1/17/13	Start Qty: 20.00 Req'd Qty: 20.00	*20 *20		Çust Item Customer:							
Approvals:		an: .	Date:	Tooling: SPC (Y/N):		Date:		ŀ	Run	Start Stop	*N *N	R1* R2*
Sequence ID/ Work Center II 117 *1 17* QC Quality Control)	Operation Description QC6- Inspect dimensions Memo	to drawing	Set Up/ Run Hours 0.00 DAS 27 9-19	Tool ID	Tool #	Plan Code	Accept Qty	Rejo Qty		Reject Number	Insp. Stamp
*118 *118* HandFinish Hand Finishing		Memo Remove A	LL PART MARKINGS	0.00 0.00) (A			C	113	3 <u>/1</u> /8	, 22_	

120

120 Outsource4

Outsource process - Anodize

Memo

0.00

0.00

HARD ANODIZE IAW MIL-A-8625 TYPE 3 COLOUR BLACK

P10: 22153 ATG

CZ 13/1/1/22 19

· · · · · · · · · · · · · · · · · · ·		DQA:	Date:	,
NCR: Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE			€,
	•	OA Closad:	Date	

											QA Closed:	Date	
Work Ord	er:					DISPOSITION AGAINST DEPARTMENT/PROCESS							
Part f						Rework Scrap Use-as-is Work Order Update			Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					Descri	ption of work order update	T	nitial	Ac	tion	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Ch	ief Eng	Desc	cription	Date	Verification	QC Inspector
Doc/Data						-							
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Setup Other	\vdash							١.					
Process													
Supplier													
Training													
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	1		1	<u> </u>		F	AUL	T CATE	GORY		· I		
Landi	ng (Gear				General							
		Bending				Bend		Grain			Ovalized		Pressure/Forced
		Centre No	ot Concer	ntric to	o/s 🗌	BOM/Route		Hardwa	are		Over/Under	tolerance	Temperature/Cure
		Cracks				Broken/Damaged		Inspect	ion Incomplete		Part Incorre	ct	Weld
		Crushed/	Crimped.			Burrs		Instruc	tions Incomplete,	/Unclear	Part Lost/M	issing	Wrong Stock Pulled
		Cuffs				Contamination		Mainte	enance		Part Moved		
	$\overline{}$	Heat Trea				Countersink	L	Mislab	eled		Positioned \		
	L	Inspection	n Strip in	Tube	<u> </u>	Cut Too Short		Misrea	d	<u> </u>	Power Loss	'Surge	Other
	<u> </u>	Ripples in			L	Drill Holes	<u>_</u>	Offset					
	L	Torque W			n L	Drawing		4	Calibration				
		Turning S			<u> </u>	Finish		Out of	Sequence			-	
L		Wave/Tw	ist in Tub	oe -		Folio		Outside	e Dimensions				

Work Ord December-19-1.				*946	380 *							Page 3
Item ID: Revision ID: Item Name:	647.9317 RH Bracket			Accept	*N900	040	100)*	Setup	Start Stop	171.	S1* S2*
Start Date: Required Date: Reference:	1/17/13 : 1/17/13	Start Qty: 20.00 Req'd Qty: 20.00	*20* *20*		Cust Item II Customer:	D:						.,
Approvals:	Process Pla	an:	Date:	Tooling: _ SPC (Y/N):		ite:			Run	Start Stop		R1* R2*
Sequence ID/ Work Center I 130 *120* Packaging Packaging 140 *120* QC Quality Control	D	Operation Description Receive & Inspect for Dan Memo ***IDENTIF QC5- Inspect part comple	Y AS PER APICAL MPP-	Set Up/ Run Hours 0.00 0.00 120 BY STAMPING P#	Tool ID AND REV*** DAS 27 9-89	Tool#	Plan Code	Accept Qty	Re		Reject Number	Insp. Stamp
*150 *150* SprayPaint Spray Painting		Spray Painting per QSI00 Memo PRIME AS F	5 4.2 ER DWG NOTE #2	0.00 0.00 Prime	at ATC P/0: 22153			C	Z	_/3	יב/וו/	z 19

recised 1948p 13-12-19

									DQA:	Date:	,
NCR: Ye	s / No				WORK ORDER NON-C	ONFORM	MANCE / UP	PDATE	QA Closed:	Date:	. ·
Work Order:	:				DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part No).				Rework Scrap Use-as-is Work Order Update	Thern	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	•	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				Descrip	otion of work order update	Initial	Ad	ction	Sign &		
Cause	Date	Step	Qty	0	r Non-conformance	Chief Eng	Desc	cription	Date	Verification	QC Inspector
quip/Tooling Operator Material etup Other Process Supplier Training Unapproved							·				
mapproved 1	<u> </u>	l	L	L	F	AULT CATE	L GORY			1	

Grain

Hardware

Maintenance

Out of Calibration

Outside Dimensions

Out of Sequence

Mislabeled

Misread

Offset

Inspection Incomplete

Instructions Incomplete/Unclear

Pressure/Forced

Weld

Other

Temperature/Cure

Wrong Stock Pulled

Ovalized

Part Incorrect

Part Moved

Part Lost/Missing

Positioned Wrong

Power Loss/Surge

Over/Under tolerance

General

Bend

Burrs

BOM/Route

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

Broken/Damaged

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Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Landing Gear

Bending

Cracks

Cuffs

Heat Treat

Crushed/Crimped.

Inspection Strip in Tube

Torque Waves in Extrusion

Centre Not Concentric to O/S

Work Order ID 94680	Work	Order	ID	94680
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DAS 26 9-89

Work Orde December-19-12				*946	380*						Page 4
Revision ID:	647.9317 RH Bracket		,	Accept	*N900	040	100)* s	etup Sta	1.71	S1* S2*
	1/17/13	Start Qty: 20.00 Req'd Qty: 20.00	*20* *20*		Cust Item I Customer:	D:					. 12
Approvals:		an:	Date:	Tooling: SPC (Y/N):		ate:		R	tun Sta Sto		R1* R2*
Sequence ID/ Work Center II 160 *160* QC Quality Control 170 *170* Packaging Packaging)	Operation Description QC14- Inspect Spray Paint Memo Identify as per dwg & Stoc		Set Up/ Run Hours 0.00 0.00	Tool ID DAS 27 9-89 13/12/19	Tool#	Plan Code	Accept Qty 19	Reject	Reject Number	Insp. Stamp
190 *1 QAA* QC Quality Control		QC21- Final Inspection - V Memo	Vork Order Release	0.00				<u>M</u> L	5 \ []((3-12-3	23 .0

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											DQA:	Date:	,
NCR:	Yes	/ No				WORK ORDER NON-	COI	NFORM	ANCE / UPD	ATE	,		ŧ.
									_		QA Closed:	Date:	
Work Ord	or.					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part I	. No.					Rework Scrap Use-as-is Work Order Update		t Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	1	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					Descri	ption of work order update		Initial	Actio	on	Sign &		
Cause		Date	Step	Qty	(or Non-conformance	Ct	nief Eng	Descri	otion	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved						·							
		·					AUI	LT CATE	GORY				
Landi		Bending Centre No Cracks Crushed/O Cuffs Heat Trea Inspection	Crimped. .t n Strip in		o/s	General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short		Instruct Mainte Mislabe Misreac	on Incomplete ions Incomplete/Ui nance led	nclear	Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned N	ct issing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
	1 1	Ripples in	Bena		1	Drill Holes	1	Offset					

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order ID:

94680

Parent Item:

647.9317

Parent Item Name:

RH Bracket

Start Date: 1/17/13

Required Date: 1/17/13

Page 1

Start Qty: 20.00

Required Qty: 20.00

Comments:

IPP REV:A NEW ISSUE 12-11-19 JLM VERIFIED BY:DD

Comments.	III KEVAN NEW	10002 12 11 17	J.D. 11 1 L.	111111111111111111111111111111111111111									
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
647.9317P		Purchased	No				Each	0.0000		20	65	7 93/	10(19)
RH Bracket M7075T6B1.500X8.500		Purchased	No				f	12.0400		21.052632			
7075-T6 BAR 1.500' X 8.	500"											and the section	

 Location
 Loc Oty
 Loc Code

 MAT049
 12.04

 124030
 12.04

124383

21.053 alisoplas

NCR:	Yes	/	No
NCR:	Yes	/	No

											-	DQA:	Date:	
NCR:	Yes	/ No					WORK ORDER NON-C	OI	NFORM	MANCE / UPE	DATE	QA Closed:	Date:	:
Work Ordor						DISPOSITION AGAINST			AGAINST DE	DEPARTMENT/PROCESS				
Part No						Rework Skid-tube Machining Thermoforming Work Order Update Large Fab		Machining	Crosstube Small Fab Finishing Composite	-1	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other		
INCR	NU.			1	.	į					` \	1	Jupplier [
Root Cause		Date	Step	Qty	Desc	-	tion of work order update r Non-conformance	1	Initial lief Eng	Acti Descr		Sign & Date	Verification	QC Inspector
oc/Data puip/Tooling perator laterial etup ther rocess upplier raining				_	-									ě
								AUL	T CATE	GORY				
Landi	ing (Bending Centre Not Concentric to O/S Cracks Crushed/Crimped. Cuffs					General Bend BOM/Route Broken/Damaged Burrs Contamination		Grain Hardware Inspection Incomplete Instructions Incomplete/Unclear Maintenance		Jnclear	Ovalized Over/Under tolerance Part Incorrect Part Lost/Missing Part Moved		Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled
		Heat Treat Inspection Strip in Tube Ripples in Bend Torque Wavès in Extrusion				Countersink Cut Too Short Drill Holes Drawing		Mislabe Misread Offset Out of 0			Positioned V Power Loss/		Other -d	
	Turning Sequence			-	Finish		1	Sequence				·		

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Wave/Twist in Tube

Folio



Ottawa, Ontario K1B 4S6

Phone # 613-899-2405

Packing Slip

Date	Invoice #
11/18/2013	748

Ship To

Main Finished Goods Location Dart Aerospace 1270 Aberdeen Street Hawksbury, Ontario K6A 1K7

P.O. No.	Ship	Via	FOB	Project
19277	11/18/2013	delivered	Archer	

Qty	Item Code	Description
19	Sales	647.9617P HST (ON) on sales
magana, ja jamanagan da unandika sasasanka ari melesari hadi ka da		



2228 Gladwin Cres. Ottawa, Ont. K1B 4S6

Telephone (613) 899-2405 Fax (613) 226-1719

Certificate of Compliance

To: Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury Ont. K6A 1K7

18 November 2013

Po Number	Part Number	Quantities		
19277	647.9317P	19		

It is hereby certified that all articles mentioned above are in conformance with the requirements, specification and drawings as listed on customer purchase order number, 19277 issued by Dart Aerospace Inc.

Greg Kumpula Quality Inspector

Archer Precision Inc.

2228 Gladwin Cress.

Ottawa, Ontario

K1B 4S6



A.T.G. Industries Inc. 731, rue Industrielle Rd. PLATING DEPARTMENT Rockland, On K4K 1T2 Canada

Ph: (613) 446-4544 Fax: (613) 446-4556

Pack List

Number: 62794

Date: 18-Dec-13

То

DART AEROSPACE LTD 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 Canada **Ship To**

DART AEROSPACE LTD 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7

Canada

Ph: 613-632-5200

Fax: 613-632-1185

Ph: 613-632-5200

Fax: 613-632-1185

	Pay	
	Pov	
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	Nev.	
SS N		
PO: 22153	Line:	
formance		
in this shipment are in confo	ormance	
RMS APPLY		
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	SS N PO: 22153 Informance in this shipment are in confo	SS N PO: 22153 Line: Informance in this shipment are in conformance d drawings referenced in the purchase order. GISTERED